

Date: Thursday, 09/10/2008 10:23:18 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	EC 135 SKIDTUBE ASSEMBLY
Job Number :	42525		
Estimate Number :	12472		
P.O. Number :		Part Number :	D135751011
This Issue :	09/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3507 UNDER REVIEW <i>Rev C</i>
First Issue :	//	Project Number :	N/A <i>11/08/10/09</i>
Previous Run :	41333	Drawing Revision :	C
	Type :	Material :	
	SKIDTUBES	Due Date :	05/11/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<i>JLD 08.10.09</i>		
Comment :	Est Rev:A 06-06-21 New Issue JLM Est Rev:B 06-12-18 As per Rev B JLM Est Rev:C 07-12-11 ECN 1036 as per revB DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 08.10.20



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

2.0	D2962150	3.540 Outer Tube, Extrud
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion *28672**RT 08-10-15*

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

RT 08-10-15

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

RT 08-10-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185 *RT 08-10-14*

2-Cut Aft end at VC using DT8185

3-Deburr ends

4-Drill Aft & Fwd Cap holes using DT8678 + *DT8901*

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with *1/8" AFT CAP* in Ground wire hole, then Pilot Drill all X-Bolt holes using *#30* 3/16" drill. ****DO NOT OPEN AFT CAP HOLES**** *open x bolt holes to .3125*

7-Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. *ND/ 8-10-23*

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

9-Open Aft & Fwd Cap holes using .208" drill. *AWM 8-10-27*

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Deburr holes.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *S 08/10/27*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *D 8-10-28*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *8-10-28*

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D35043	Crossbolt Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSBOLT SPACER

Batch: B31232

BE 08/10/30

10.0	D35041	Crossbolt Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

Batch: B31234

BE 08/10/30

11.0	D35051	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Batch: B341604

DP 8-10-28

12.0	D35061	Doubler
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

DOUBLER

Batch: 41605

SL 8-10-31

13.0	D35063	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

Batch: 28963

SL 8-10-31

14.0	D35045	Crossbolt Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

Batch: B336181

BE 08/10/30

15.0	MS20601AD4W3	Rivet
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch: 107823

SL 8-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42525

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M109449
Exp Date: 8-11-30

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: m109213 8-10-30

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

Tools: E

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507.

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
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Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(P)

Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

FZ 08/11/05

21.0	POWDER COATING	POWDER COATING
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M109152



(TX)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
320 OF
9:50

M 08/11/05

22.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-06

(X)

23.0	ALS71032130	Insert
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M105819

HL *

24.0	ALS41032225	Insert
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: M100621

HL

25.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3507.

HL 08-11-06 (X)

26.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

S 08/11/06 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42525

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN526C1032R10	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch M 108062 *JH*

28.0	D29653	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B 29993 *JH*

29.0	D2965	Cap, 105 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B 41523 *JH*

30.0	D35081	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B 31195 *JH*

31.0	D35083	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B 38527 *JH*

32.0	D35085	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B 31197 *JH*

33.0	D35087	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B 36179 *JH* 08.11.06 (V)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 42525

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	D35581	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342533

24

35.0	D35583	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342253

24

36.0	D35585	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 134132411

24

37.0	D35587	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1336388

24

38.0	D3492041	Plug Assembly
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

Batch: 1342637

24

39.0	D3492043	Plug Assembly
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

batch 1342183

24

40.0	D3492047	Plug Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

Batch: 1528961

24

08.11.00

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 42525

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	AN960C10L	washer
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Comment: Qty.: 33.0000 Each(s)/Unit Total : 33.0000 Each(s)

Washer

Batch: (12x) M109545 (21x) M109752 JK

42.0	AN3C4A	BOLT
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Comment: Qty.: 31.0000 Each(s)/Unit Total : 31.0000 Each(s)

BOLT

Batch: M109431 JH

43.0	AN3C5A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109752 JH

44.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

- ✓ 1-Inspect for Foreign objects
- ✓ 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"
A/R 241 Sika Flex Batch: M109449
Exp Date: 08/11
- ✓ 3-Install Wearplates as per Dwg D3507 ,
Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Scews where indicated on Dwg (Note #6)
A/R 241 Sika Flex Batch: M109449
Exp Date: 08/11
- ✓ 4-Install Plug assemblys as per Dwg D3507.

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

M109219. →

FD 08/11/06 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description :

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/13 (1)
plugs installed

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D35121

Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARPLATE

Batch: 40360

SS 08/11/13 (X1)

48.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M105793

SS 08/11/13 (X1)

49.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

BATCH: M109001

Batch not in comp

SS 08/11/13 (X1)

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/11/13 (1)

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751-011

Location: 82

PPP Rev: B

8/11/13

(15)

SC

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/14 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-13

B42525

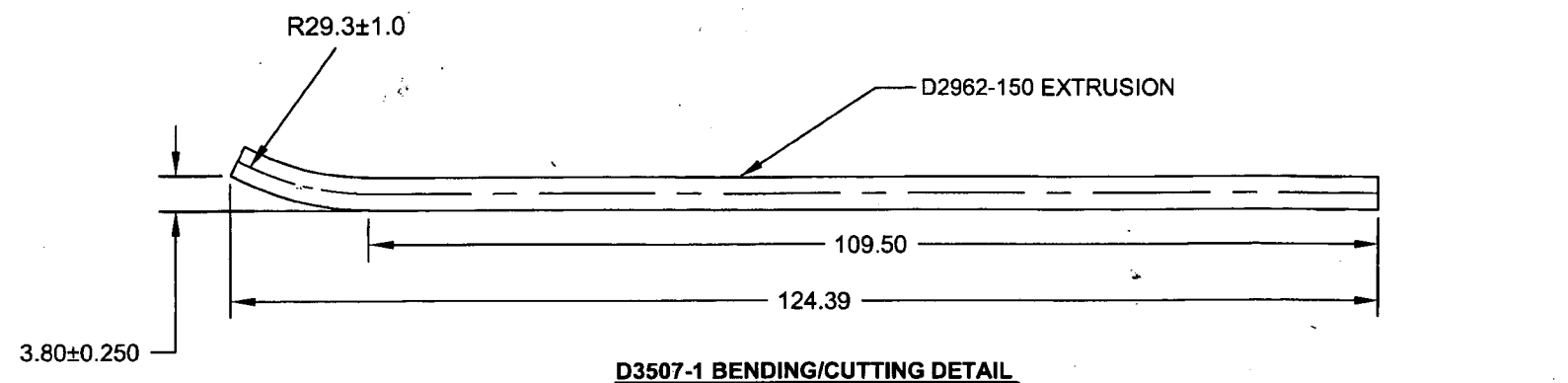
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

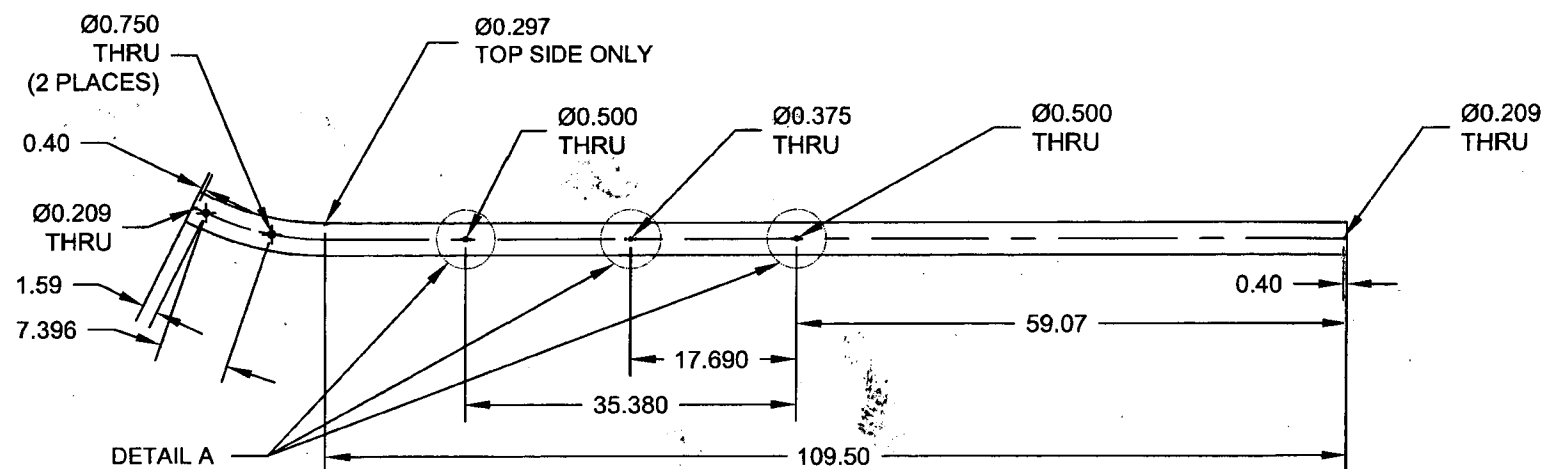
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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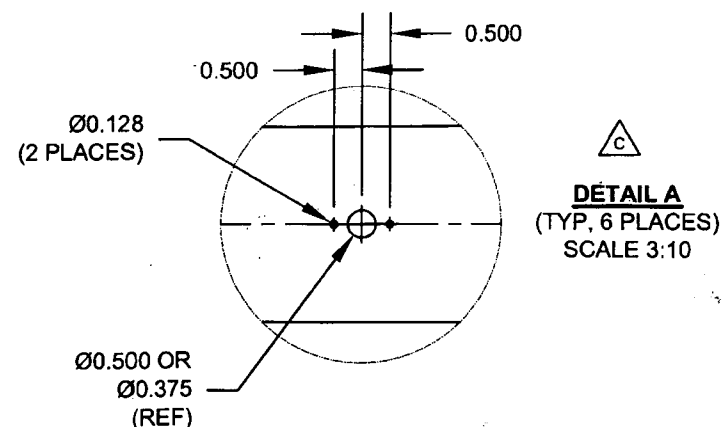
NOTE: Date & initial all entries



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

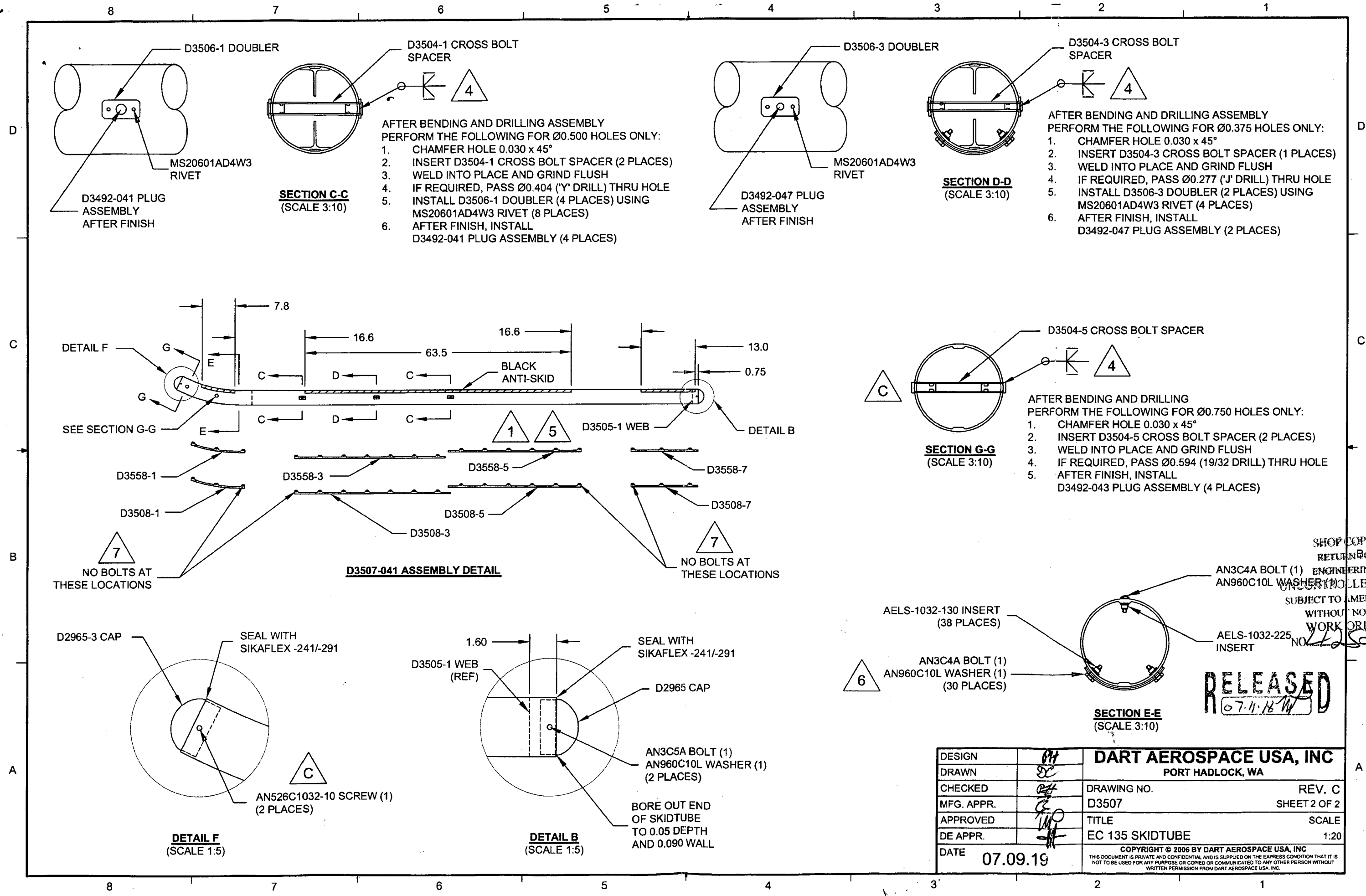
GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

RELEASED
07-11-16

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JC		
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MFG. APPR.	EP	D3507	SHEET 1 OF 2
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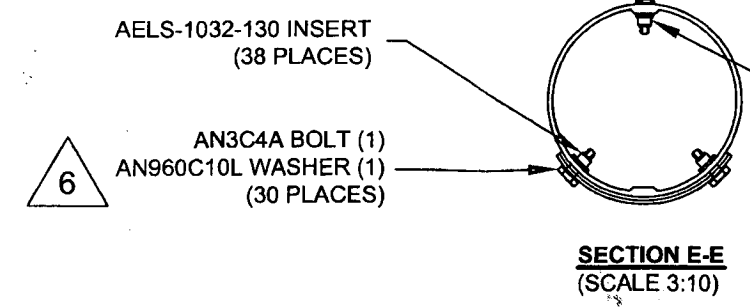
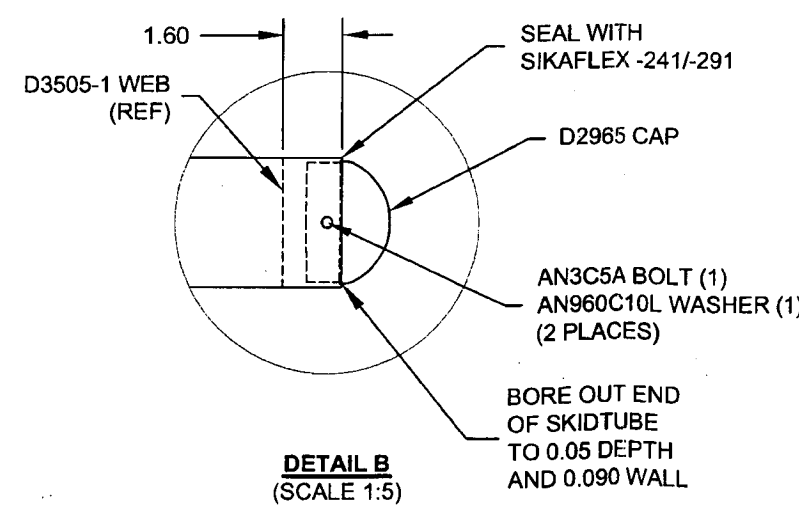
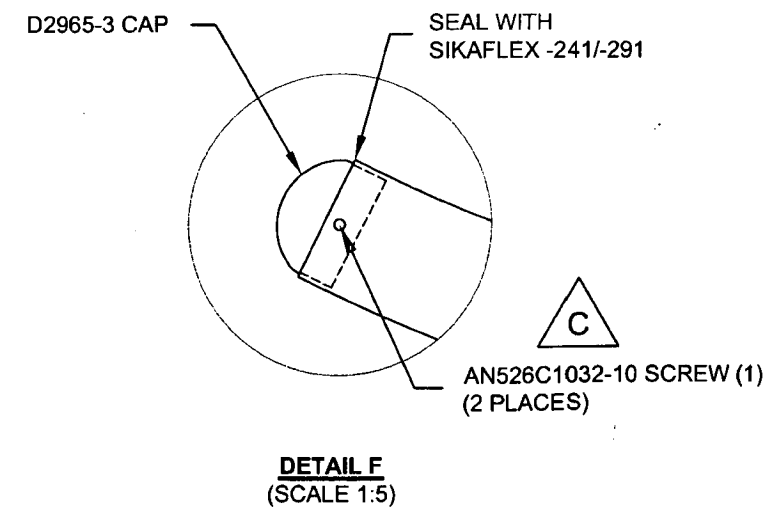
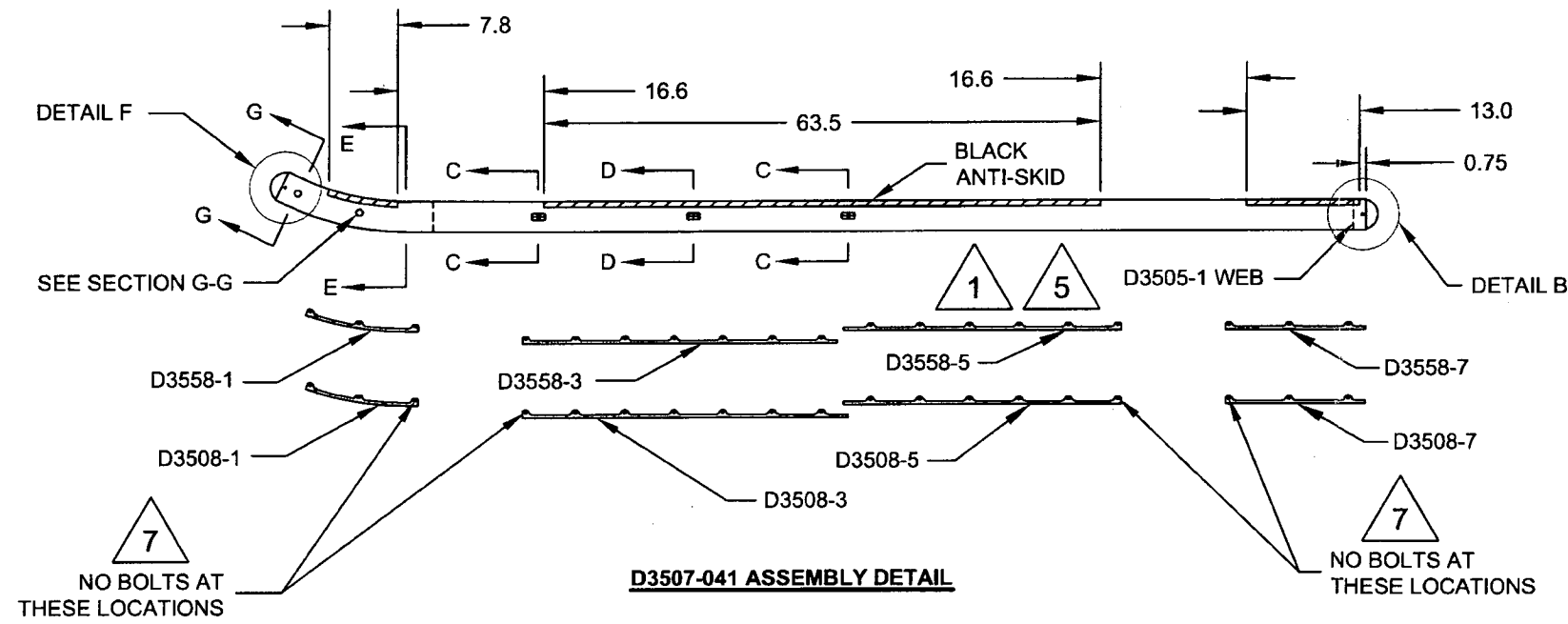
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- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 ('J' DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)

- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 ('Y' DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)

- AFTER BENDING AND DRILLING
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER (2 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY (4 PLACES)



DESIGN	04	DART AEROSPACE USA, INC	
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DE APPR.	04	EC 135 SKIDTUBE	1:20
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AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 841333
Part number: 135 751011
Description: SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Lund Date of Test Coupon 08/10/22
Welder Barclay Elliot Date of Test Coupon 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld